

Date: Friday, 25/07/2008 7:11:57 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: AFT CROSSTUBE		
<b>Job Number</b>	: 40754			<b>Part Number</b>	: D2890		
<b>Estimate Number</b>	: 10377			<b>Drawing Number</b>	: D2890 REV B		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 25/07/2008	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: B		
<b>Prsh Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / /	<b>Type</b>	: CROSSTUBES	<b>Due Date</b>	: 01/08/2008	<b>Qty:</b>	1
<b>Previous Run</b>	: 38819			<b>Um:</b>	Each		
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	:						
<b>Comment</b>	: Est. D 05.03.21 Removed Bending procedures KJ/JLM						

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
1.0	D6008180	Crosstube Extrusion
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part # Description Batch 1 D6008-180 Crosstube extrusion <u>402711</u>		
2.0	BENDING	BENDING MACHINE - SKIDTUBES
<b>Comment:</b> BENDING MACHINE 1-Bend D2890 as per Dwg D2890 and Folio FT002 <u>M 8-7-24</u>		
3.0	QC6	DIMENSIONAL CHECK
<b>Comment:</b> DIMENSIONAL CHECK <u>10607-050</u>		
4.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1
<b>Comment:</b> LANDING GEAR RESOURCE 1		
1-Deburr and Polish <u>N/A</u>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: AFT CROSSTUBE

Job Number: 40754

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 (-10A)

Identify and Stock

Location: W10 38793

080725D

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-25

08/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

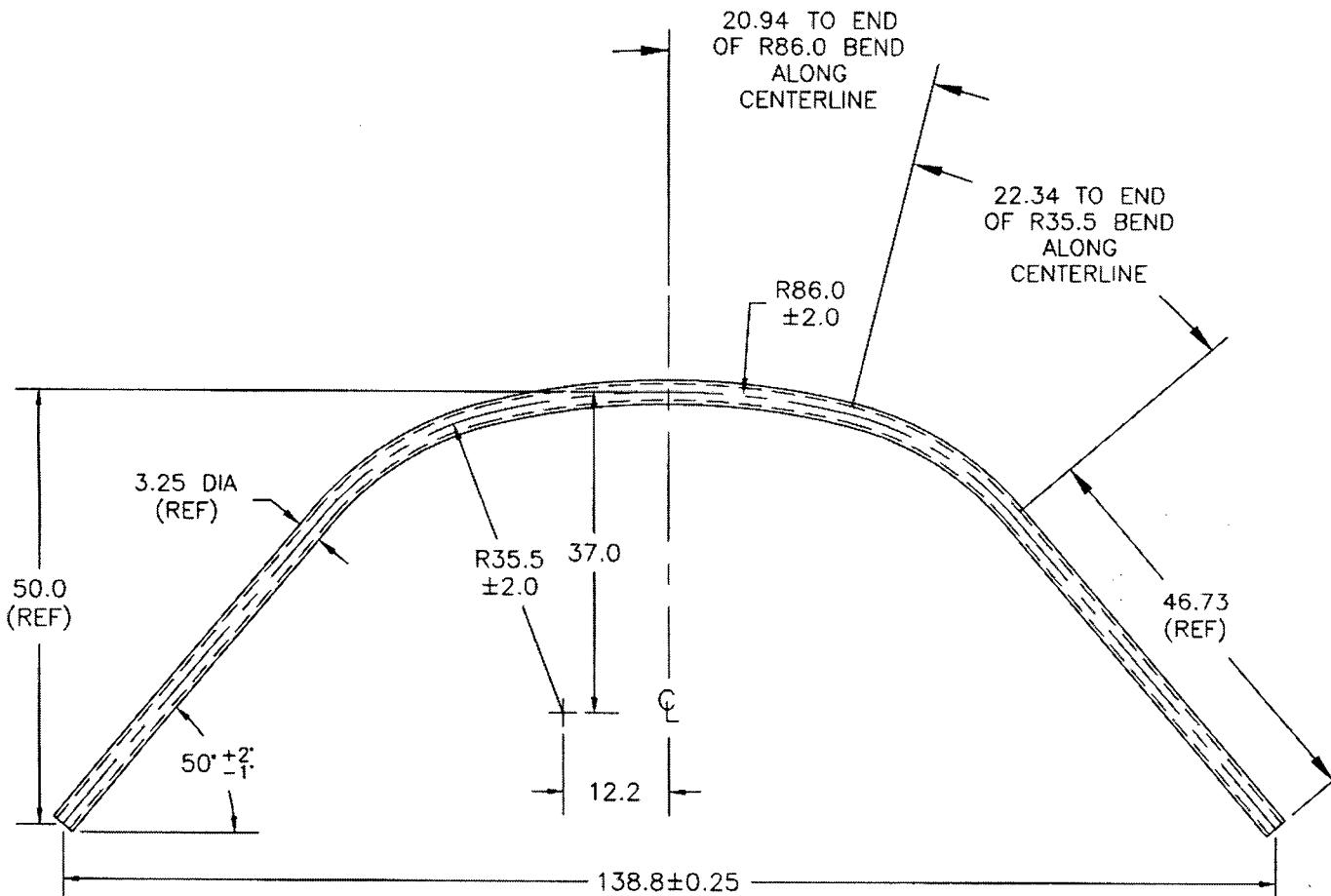
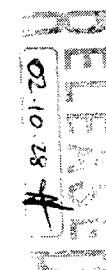
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

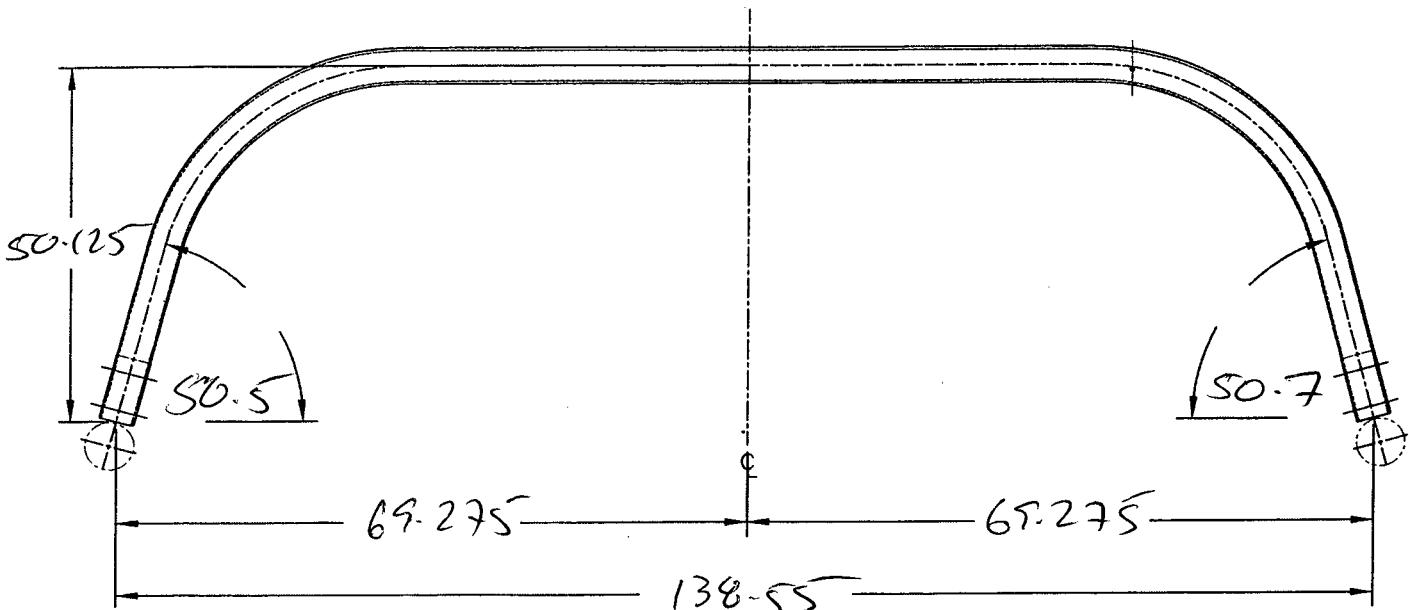
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
		REV. B
		DRAWING NO.
		D2890
DATE		SHEET 1 OF 1
02.10.18		SCALE
A	99.05.21	1:20
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES

NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 ( $\phi 3.25$  OD x 0.438 WALL)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) PART IS SYMMETRIC ABOUT CENTERLINE
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
  - 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- WD  
WPSU*

DART AEROSPACE LTD	Work Order:	40754
Description: Crosstube Aft	Part Number:	D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments

QC15 Inspection	<i>[Signature]</i>
Date	07/02/05

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	